

Work Order ID 74466

Friday, September 30, 2011 1:50:50 PM



Page 1

Item ID:	D4035-045	Accept		Setup	Start	
Revision ID:						
Item Name:	Lid Rib Assembly, Fwd (Light)			Stop		
Start Date:	9/30/2011	Start Qty:	2.00			
Required Date:	10/6/2011	Req'd Qty:	2.00			
Reference:						

Approvals:	Process Plan: <u>MLJ</u>	Date: <u>11/09/30</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4035	A								

100 Weld per dwg A/R Aluminum rod Batch: 0.00



Large Fab

Memo

0.00

Large Fab

- 1- Cut D4035-1 as per dwg D4035
- 2- Drill holes as per dwg D4035 using DT9619
- 3- remove identification marks and deburr
- 4- Weld bushing in rib as per dwg D4035

4 SAD 12-04-04
ll
12-04-25

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

4 0 BE12-04-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74466

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Page 2

Item ID: D4035-045 Accept  Setup Start 
Revision ID: Stop 
Item Name: Lid Rib Assembly, Fwd (Light)
Start Date: 9/30/2011 Start Qty: 2.00  Cust Item ID:
Required Date: 10/6/2011 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start 
Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00 <i>5.26/26</i>							
130  Packaging Packaging	Identify as per dwg & Stock Location: <i>MA</i> Memo	0.00 0.00				<i>4</i>	<i>0</i>	<i>hl</i> <i>12.04.26</i>	
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						<i>12/4/30</i> <i>df</i>	

12-04-27

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Picklist Print

Friday, September 30, 2011 1:51:01 PM

Page 1

Work Order ID: 74466

Parent Item: D4035-045

Parent Item Name: Lid Rib Assembly, Fwd (Light)

Start Date: 9/30/2011


Required Date: 10/6/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 10.01.25 verified by:EC
per dwg revA 10.03.15 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2953-175  Spacer		Manufactured	No			100	Each	33.0000	1	2		12.04.25	
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Location	Loc Qty	Loc Code
WA	17	
72847	17	
WA005	16	
57335	14	
65919	2	

M6061T6TS0.750W.06 2		Purchased	No			100	f	172.4533	1.875	3.947368			
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6061-T6 SQ Tube .75 x .75 x .062W

Location	Loc Qty	Loc Code
MAT006	20.16379	
104422	4	
116687	1.16379	
9671	15	
MAT013	152.289506	
117400	152.289506	

7.895

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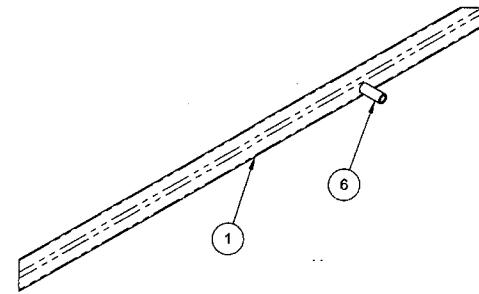
NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING

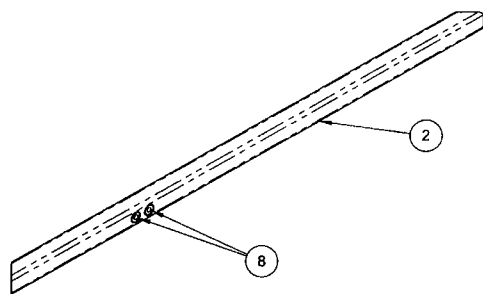
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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74466

M.L. J

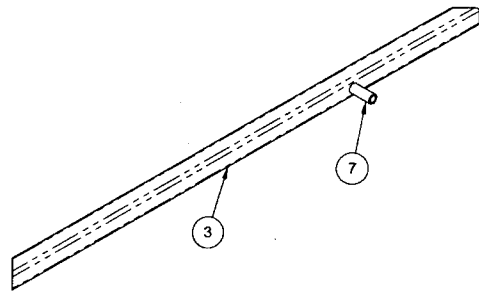
11/09/30



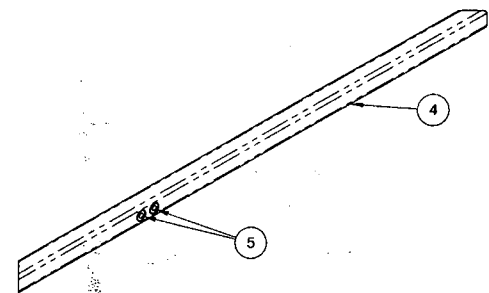
D4035-041 BASKET LID RIB ASSY, FWD



D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
2010-03-12

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID RIB ASSY	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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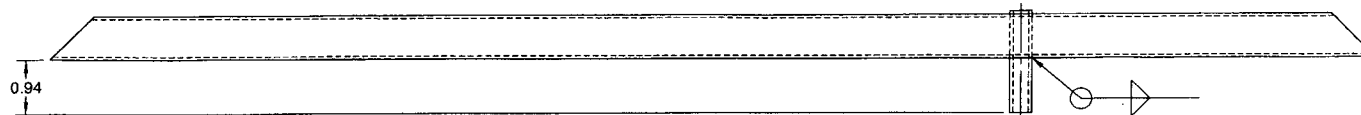
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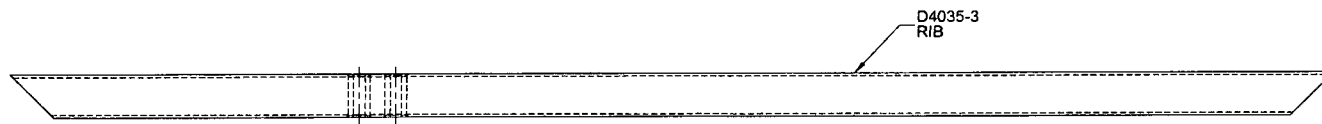
74466



D4035-1
RIB

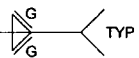
D2327-3
SPACER BUSHING

D4035-041 BASKET LID RIB ASSY, FWD



D4035-3
RIB

D4021-9
BUSHING
2 PL



D4035-043 BASKET LID RIB ASSY, AFT

RELEASED
2010-03-12

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.83 lbs
 - 8) WELDING: PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 2 OF 5
APPROVED		TITLE	SCALE
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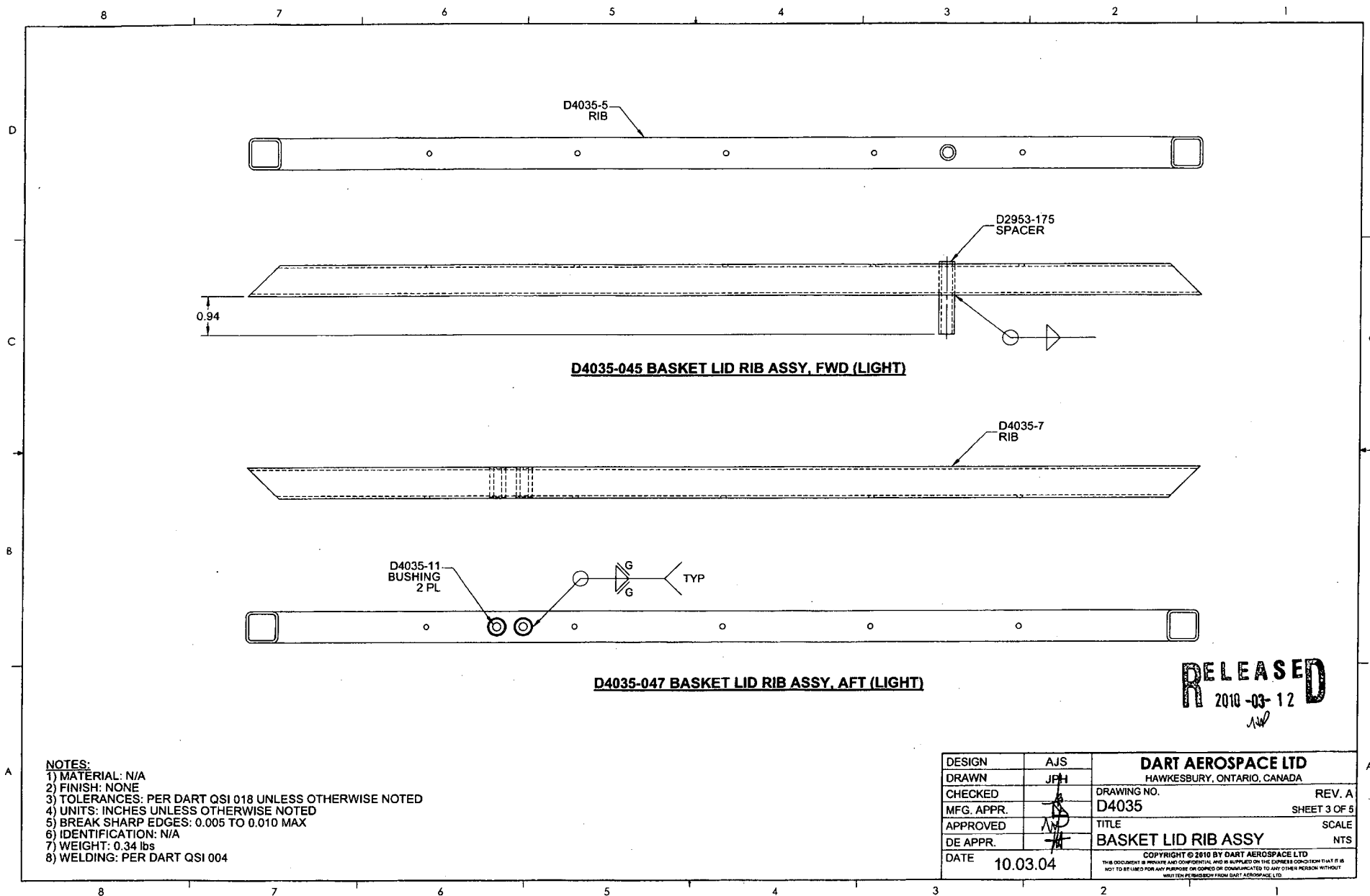
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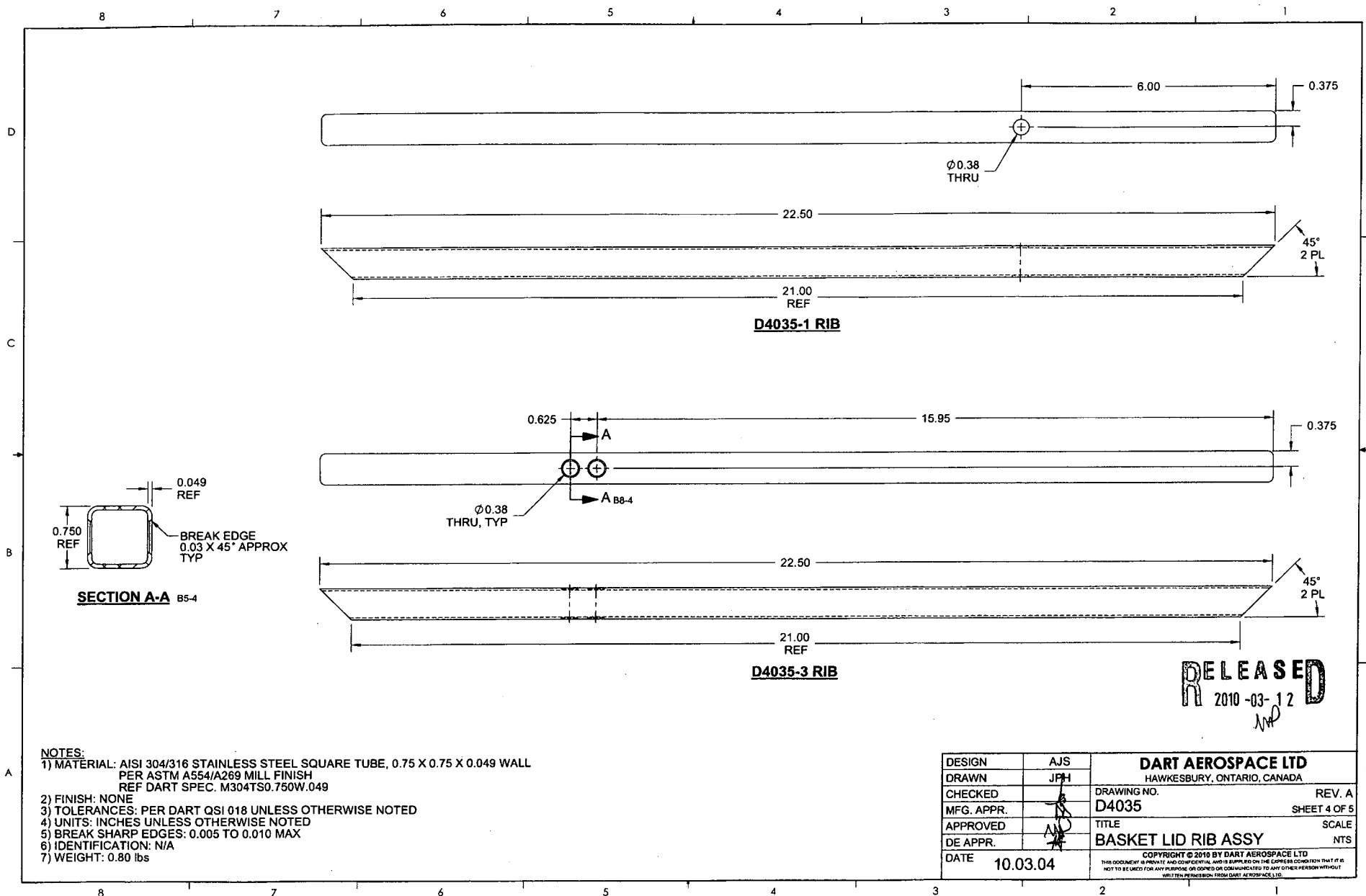
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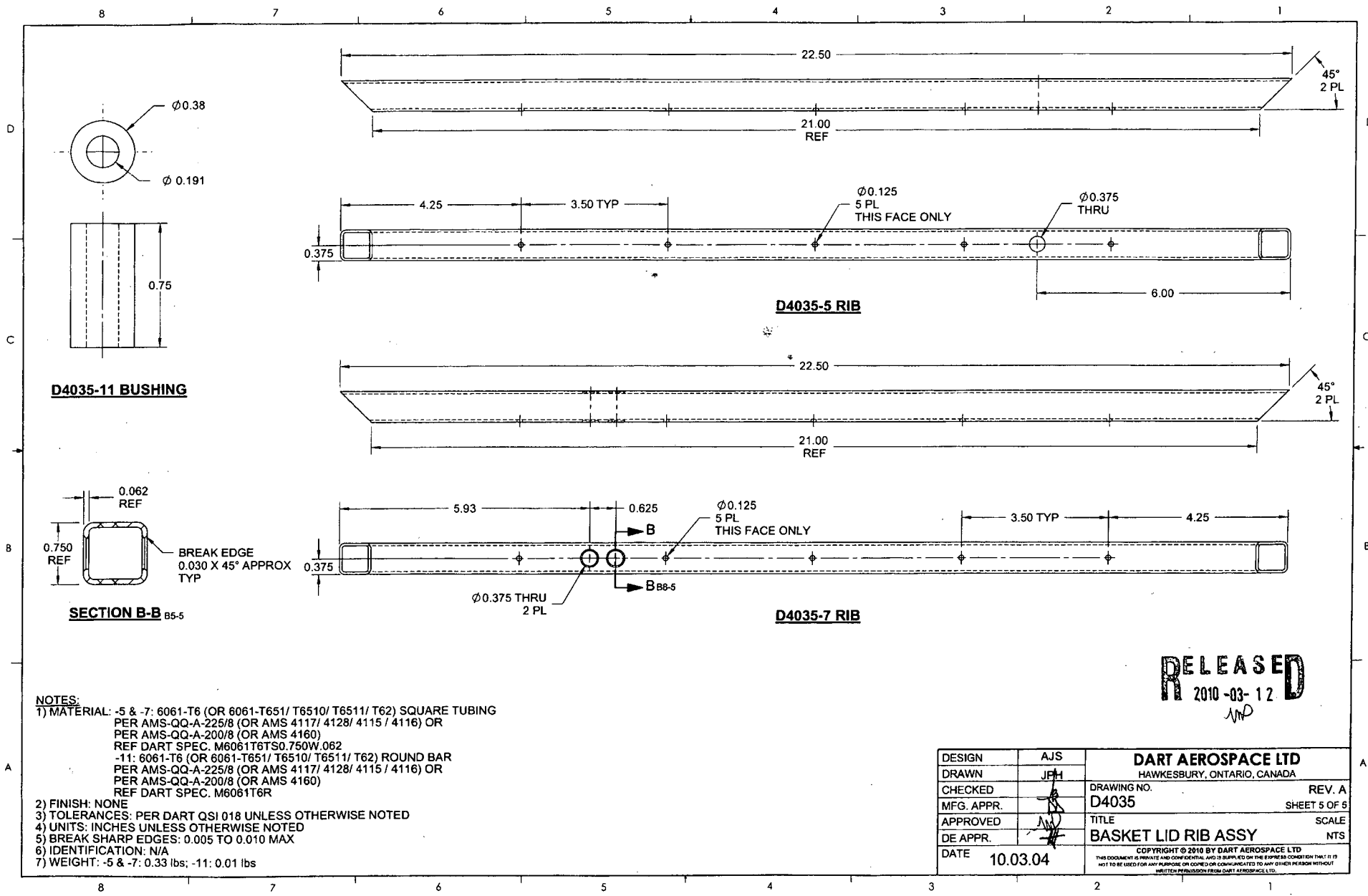
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MD

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CHECKED		DRAWING NO.	REV. A
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APPROVED		TITLE	SCALE
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